

**INSTALLATION  
INSTRUCTIONS****2005-2006 ISB 02 200 HP (EEA)****WARNING**

**PERSONAL INJURY. Never operate heater if element is not immersed in coolant.** Element sheath could burst and cause personal injury.

**HEATER DAMAGE. Never run engine while heater is in operation.** Shortened heater life will result.

**HEATER DAMAGE. DO NOT use stop leak additives or improper coolant mixtures.** Shortened heater life will result.

**HEATER INSTALLATION PROCEDURE**

1. Drain engine coolant. Flush system if necessary.
2. Remove 2 1/4" core plug located on the right side of the engine. Any core plug can be used, however the plug nearest the center of the block is preferred. On turbocharged engines, do not use the opening that is near the turbocharger. The opening must have threaded bolt holes in the block for attaching the mounting plate.
3. Clean core hole surface thoroughly. Remove any burrs, paint or sharp edges on diameter of core hole. Burnish core hole surface with sandpaper or steel wool. The hardened cup plug sealant must be removed.
4. Apply a coating of lubricant to the heater O-ring to ease installation and prevent damage to O-ring. Lubricant must not be petroleum-based, use a water-based or synthetic lubricant.
5. Install heater into core hole with so that plate mounting holes line up with the threaded holes in the block.
6. Tighten bolts to 20 Nm (14.8 foot pounds).
7. Insert power cord connector firmly into socket, taking care to align pins with sockets of connector on cord. Tighten strain relief nut securely by hand.
8. Route cord to outside, securing where necessary to allow slack for engine vibration and ensure that cord does not touch engine, hot pipes, or any moving parts. Connect only to a GFCI protected 120-Volt AC outlet. If an extension cord is used, it must be the three-wire grounded type.
9. Refill cooling system with coolant mixture. Use a standard 50/50 mixture of coolant and water. Do not use more than 60% concentration of coolant as it will reduce the heater life.
10. Run engine up to operating temperature and check for leaks. Let engine run for 5-10 minutes after thermostat opens to ensure all air is bled from system.

**CAUTION**

**HEATER DAMAGE. Do not operate heater until all air is bled from system.** Shortened heater life will result.

**WARRANTY**

The Phillips & Temro Industries warranty statement is located on the website at [phillipsandtemro.com/terms](http://phillipsandtemro.com/terms).